

Next please

Dart Aerospace Ltd.

Date: Wednesday, 5/31/2006 7:40:02 AM  
User: Kim Johnston

# Process Sheet

Split 2 / 26

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 STEP ASSEMBLY, SHORT HIGH SKID
Job Number	: 27307-2		: 0607-11
Estimate Number	: 10460	Part Number	: D350591113
P.O. Number	: N/A	Drawing Number	: D2310 REV D
This Issue	: 5/31/2006 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: D
First Issue	: N/A Type : LARGE FAB ASSY	Material	: N/A
Previous Run	: 27045	Due Date	: 6/30/2006
Written By	: SEE COMMENT BELOW	Qty:	6 Um: Each
Checked & Approved By	: 06-05-31		
Comment	: Est Rev: H 04.11.09 Reformat KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-591-113 CHG003

2.0	D2244116	Step Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
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1	D2244	Step Extrusion	323404
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06-06-26

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310

2-Drill extrusion as per Dwg D2310 using drill Jig DT8230

3-Deburr

06-06-26  
06-06-26  
06-06-26

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5.0	D267334	End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
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06-06-03 (6)

Wednesday, 5/31/2006 7:40:02 AM  
Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 STEP ASSEMBLY, SHORT HIGH SKID

Job Number: 27307

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2673-34

End Cap

325394

LE 06.06.03 6

6.0

D2275

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D2275

Bushing

317557

LE 06.06.03 6

7.0

D2582

Hi-Skid Step Leg Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number

Description

Batch

1 D2582

Step Leg Assembly

325395-4  
325089-152

LE 06.06.03 6

8.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part number

Description

Batch

16 MS20600AD4W3 Rivet

M13767-66

LE 06.06.03 6

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd end cap and bushing as per Dwg D2310

A/R AL ROD

Batch:

M19173

M15689

2-Grind end cap and bottom bushing welds flush

3-Machine top weld on bushing flush

LE 06.06.05 6  
FF 06.06.05 6  
LE 06.06.05 6

10.0

QC5/9

WELD INSPECTION



Comment: WELD/WORK INSPECTION

06.06.06 6  
06/06/13 6

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 STEP ASSEMBLY, SHORT HIGH SKID

Job Number: 27307

Part Number: D350591113

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

SAD 06.06.17

(6)

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet as per Dwg D2310

2-Inspect for foreign object as per QSI 024

3-Weld Aft end cap as per Dwg D2310

A/R AL ROD Batch: m100660

4-Grind end cap welds flush

LE 06.06.28 6

LE 06.06.28 6

LE 06.06.28 6

FF 06.06.29 6

13.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

MAG 06/29 / 06.06.29 (6)

14.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

FF 06.06.29 6

15.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

AM 06-07-08 (6)

16.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2310 and QSI 005 4.4

Batch: M 101266

AM

SC 06/07/13

06-07-10 (6)

PTO on last page

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 STEP ASSEMBLY, SHORT HIGH SKID

Job Number: 27307

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*U 6/7/18 (1)*



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION AND WING WALK

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

19.0

K591113

Short Step Instln Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick Packing Kit:

Qty Part number

Description Batch

1 K591-113

Hardware Kit

*B27308*

20.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



*U 6/7/17 (1)*



Comment: INSPECT 100% KITS FOR COMPLETENESS

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-113

Location:

*Rev. H.*

*REV H*

*U 6/7/17 (1)*  
*U 06/07 (5)*

22.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*Nov. 07.19*

Job Completion



*U 06.07.17*

WORK ORDER CHANGES						
W/O:						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr
06-07-11	17	W/O was split for 1 step. See NCR below		06-07-11	1	

WORK ORDER NON-CONFORMANCE (NCR)							
NCR:							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr
			Initial Design Mgr	Action Description Design Mgr	Sign & Date		
06-07-11	16	Paint at the fuel cap bubbled up in 2 small locations. Quite possibly 2 tiny pin holes under the surface in the weld caused a pressure release, causing the bubbles.		1) → Grind smoothly removing powder coat on fuel cap location 2) → re-weld affected area to eliminate pin holes. As per QSI 004, and grind 3) → have work verified by QC 9/5 4) → Touch-up fuel cap with a loctite as per QSI 005 4.1 5) → Re-powder coat white as per RS 1004 QSI 005, 4.3.5.1 6) → wing walk as per Dwg.	06-07-11 06-07-11 06-07-11 06-07-11 06-07-11 06-07-11		

Part No: D350-591-113 PAR #: N/A Fault Category: Prod - Final NCR: Yes No DQA: 10 Date: 06.07.19

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_